

Date: Friday, 5/25/2007 8:04:43 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR RH
Job Number : 32556	
Estimate Number : 12636	
P.O. Number : <i>N/A</i>	Part Number : <u>D31864</u>
This Issue : 5/25/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 32298B	Material : <i>N/A</i>
	Due Date : 6/8/2007 Qty: 1 Um: Each
Written By : <i>[Signature]</i>	
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	32556A	SPACEPOD DOOR RH
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Comment: Sub-Component SPACEPOD DOOR RH

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

*w/o 32706*  
*ml 07/07/17*

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

*ED 07/07/17 (41)*

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*ml 07/07/17*

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*07/07/17*

Job Completion



*W 07/09/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 5/25/2007 8:04:47 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 32556A		
Estimate Number	: 12599		
P.O. Number	:	Part Number	: D31862M
This Issue	: 5/25/2007 S.O. No. :	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 32298B01	Material	:
Written By	:	Due Date	: 6/8/2007 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: \_\_\_\_\_

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

see w/o 32706

2.0

D31862P

Spacepod Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Spacepod Door

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from  
 Delastek is attached.

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 5/25/2007 8:04:47 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 32556A

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

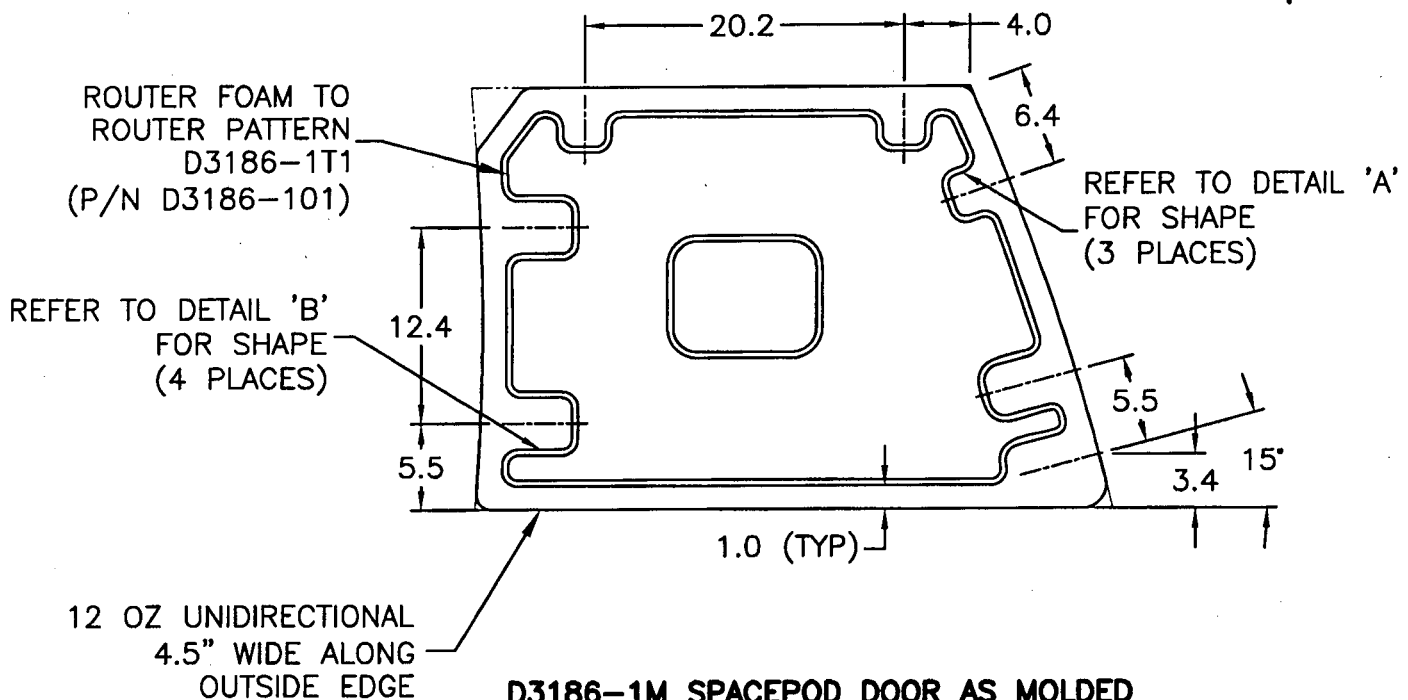
**NOTE:** Date & initial all entries

**DART**

DESIGN DS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**07.02.27 *H***NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. *32556*

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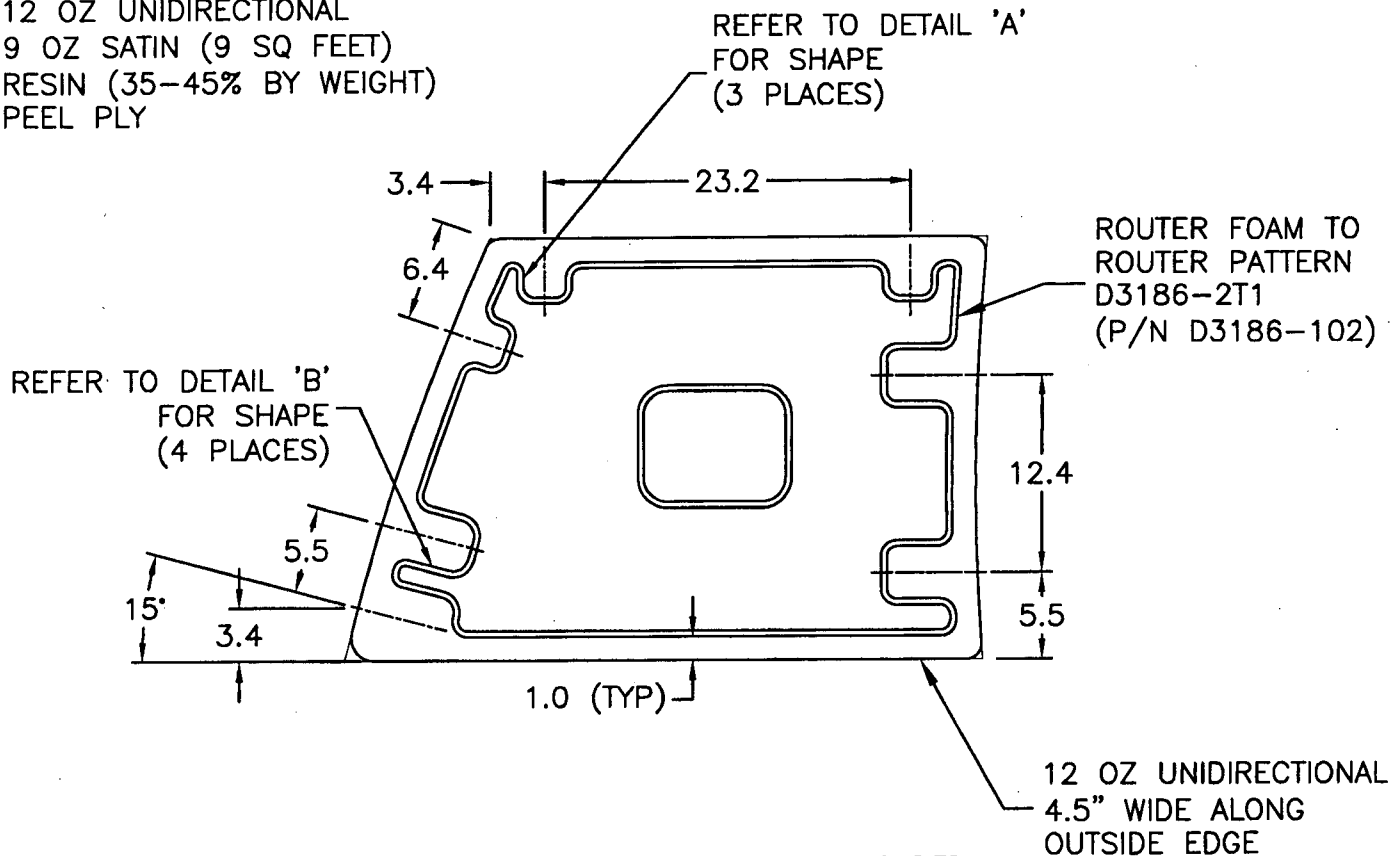
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

#### MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

RELEASED

07.02.27 [Signature]



**D3186-2M SPACEPOD DOOR AS MOLDED**

#### NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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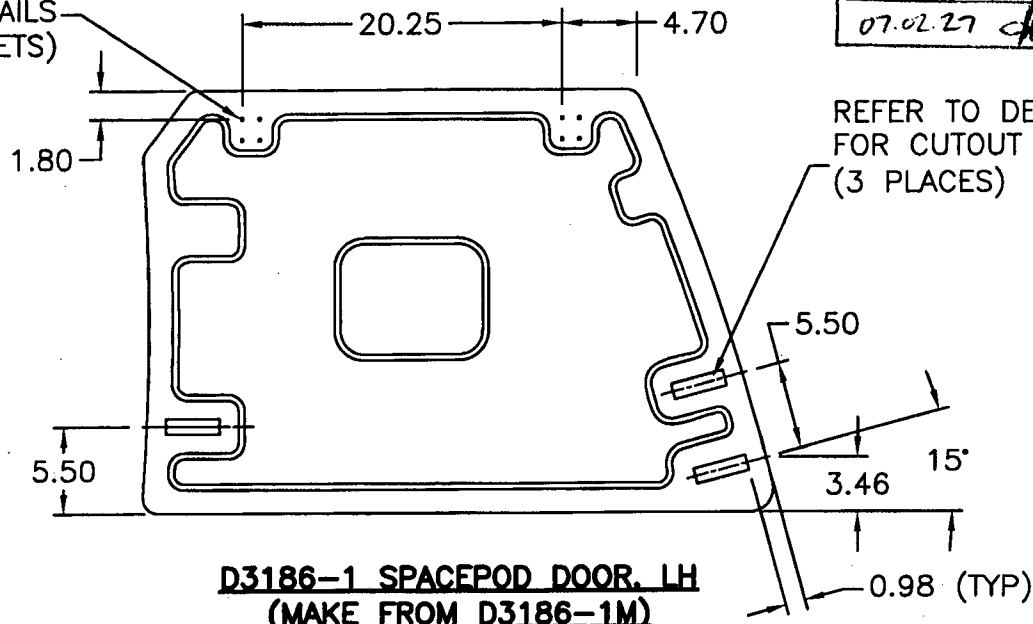
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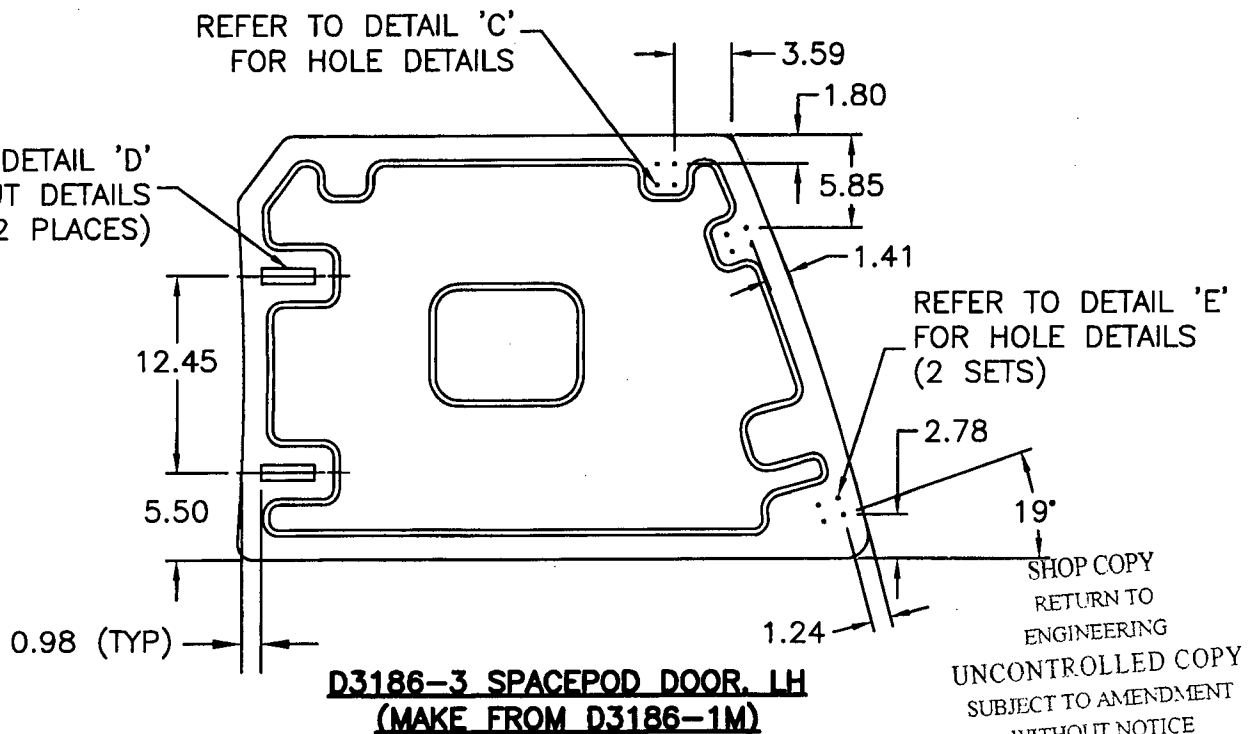
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CHECKED JB	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)



REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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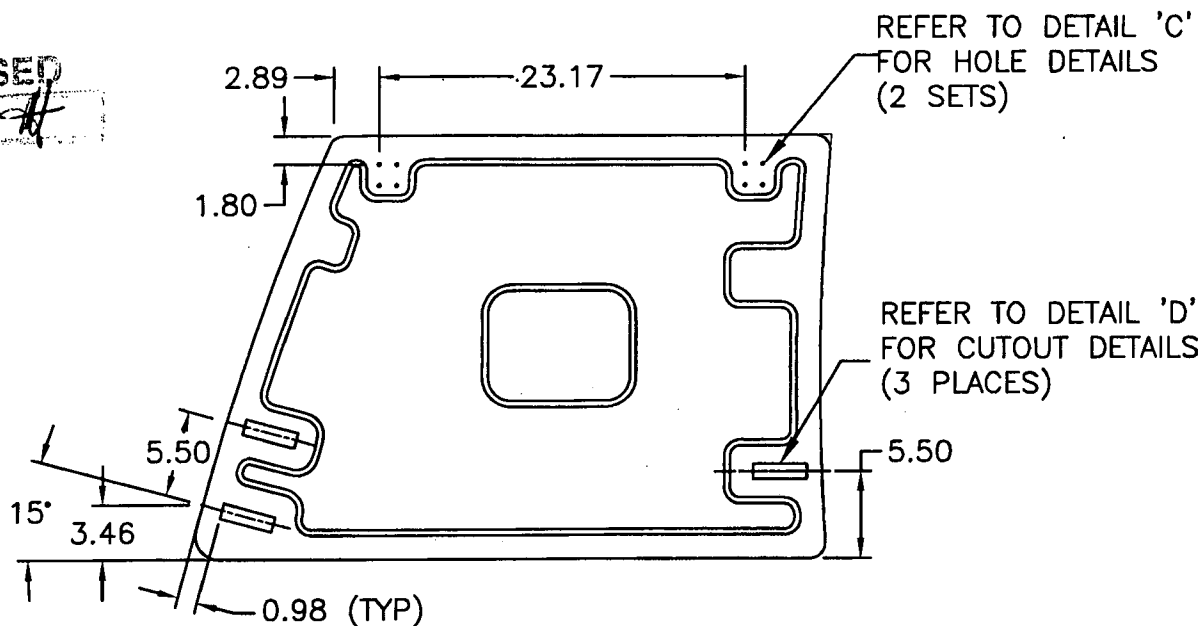
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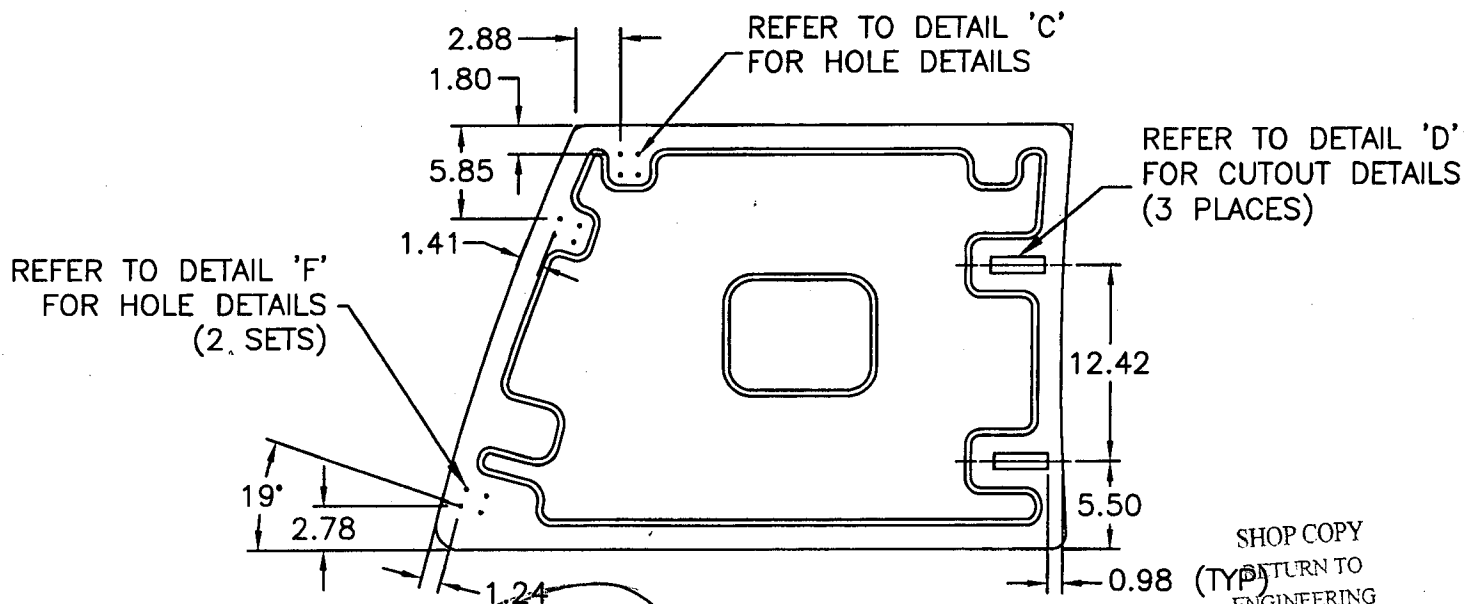
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

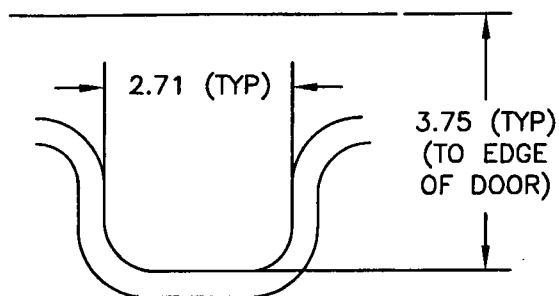
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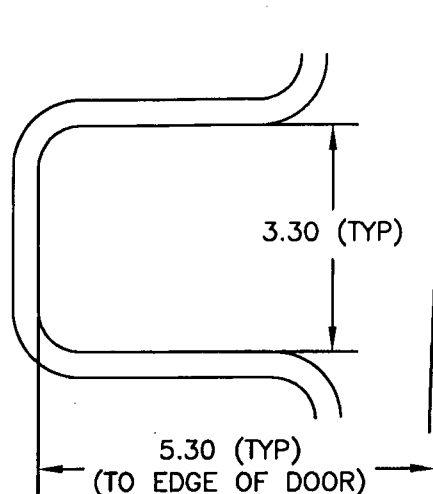
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



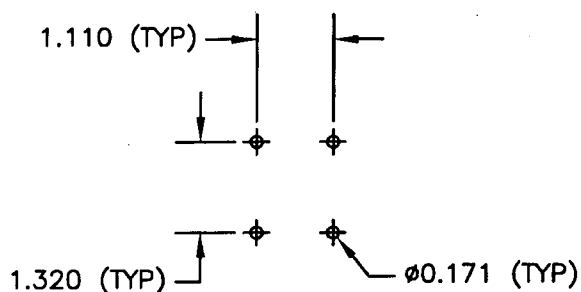
**DETAIL A**



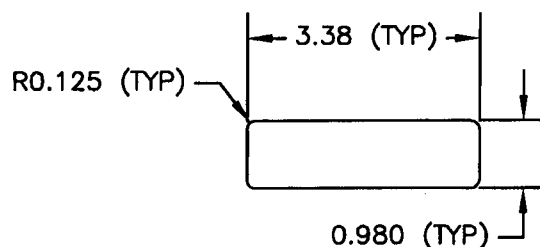
**DETAIL B**

RELEASED

07.02.27 [Signature]

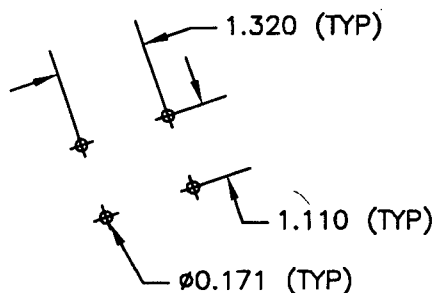


**DETAIL C**

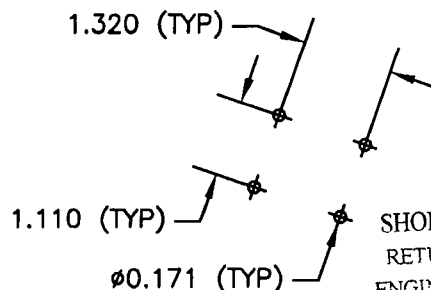


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



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WITHOUT NOTICE

WORK ORDER

NO. 32556

**NOTES:**

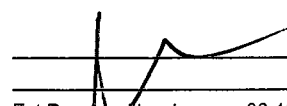
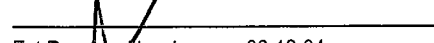
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Monday, 5/28/2007 2:38:07 PM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SPACEPOD DOOR RH
<b>Job Number</b> :	32706		
<b>Estimate Number</b> :	12599		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D31862M
<b>This Issue</b> :	5/28/2007	<b>Drawing Number</b> :	D3186 REV.D
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	D
<b>Previous Run</b> :	32556A	<b>Material</b> :	N/A
<b>S.O. No.</b> :	N/A	<b>Due Date</b> :	6/8/2007
<b>Type</b> :	PURCHASED PARTS	<b>Qty:</b>	1
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est Rev: A New Issue 06-12-04 ec est rev B rev D dwg 07.03.07 ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O:

3852

Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required.

Ship 3 Items from Previous steps

u 07-05-28

2.0	D31862M	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

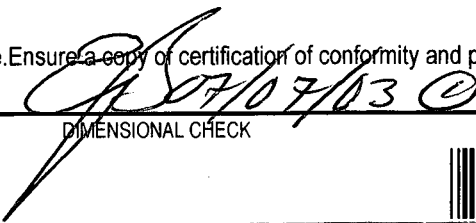
Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.



4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 . Visual inspection. Check for void spot and pins.

mul 07/07/17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 5/28/2007 2:38:07 PM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR RH

Job Number: 32706

Part Number: D31862M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

*ml 07/07/17*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*①*  
*2010/09/21*

Job Completion



*UAF-09-21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

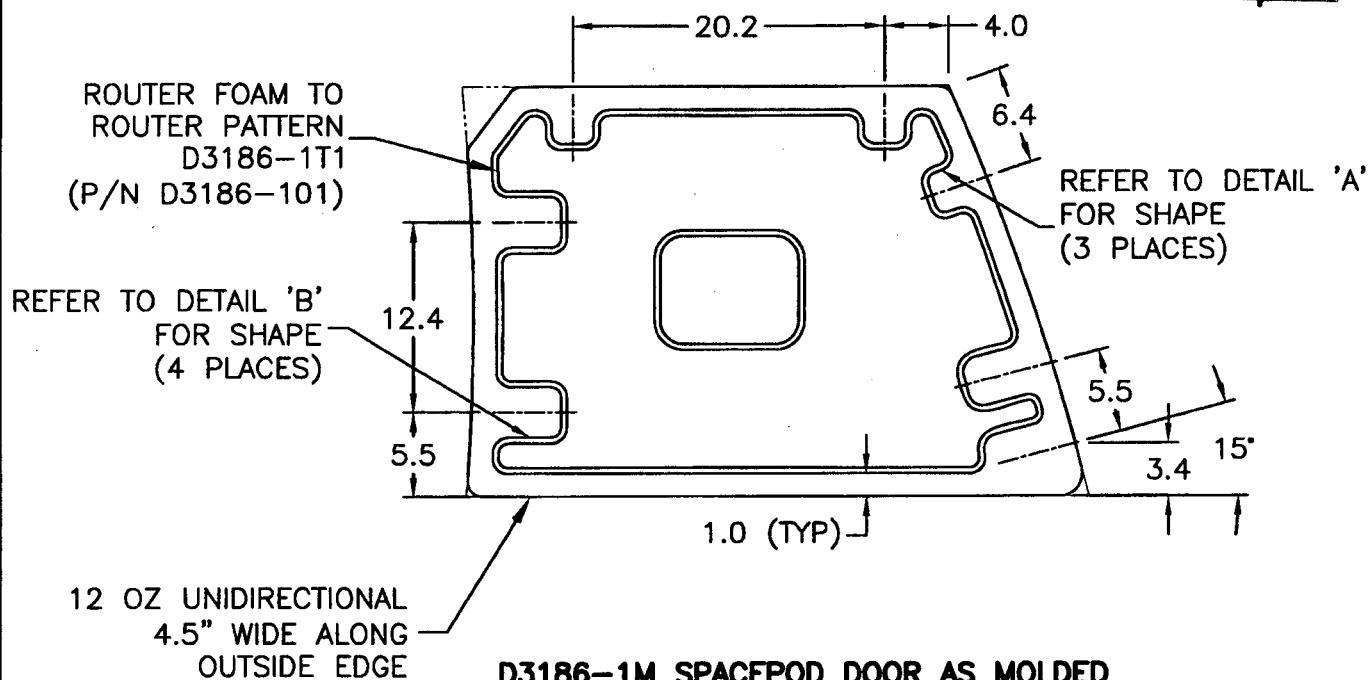
**NOTE:** Date & initial all entries

**DART**

DESIGN DS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**07.02.27 *H***D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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*C267105128*  
*w/o B 32706*

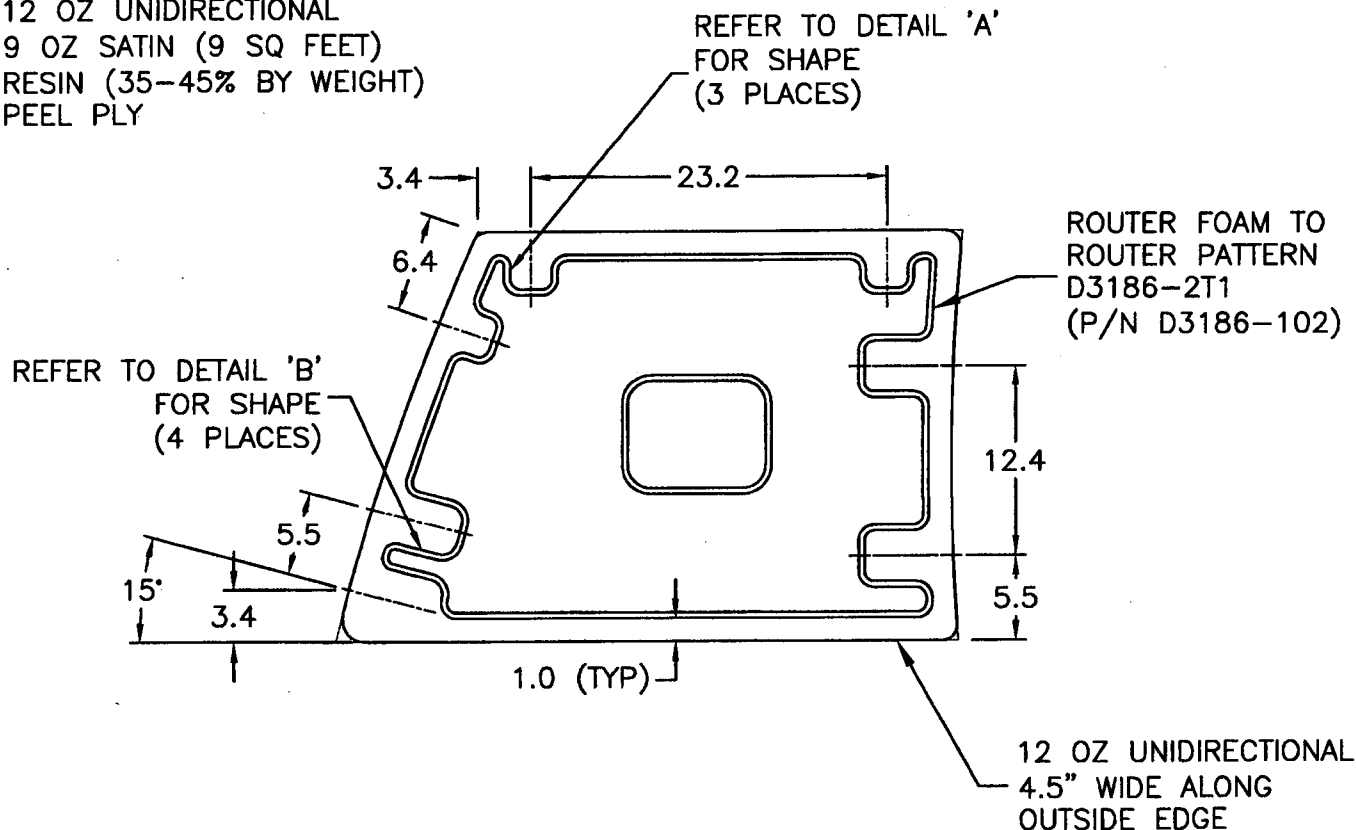


**DART**

DESIGN DS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**07.02.27 *[Signature]***D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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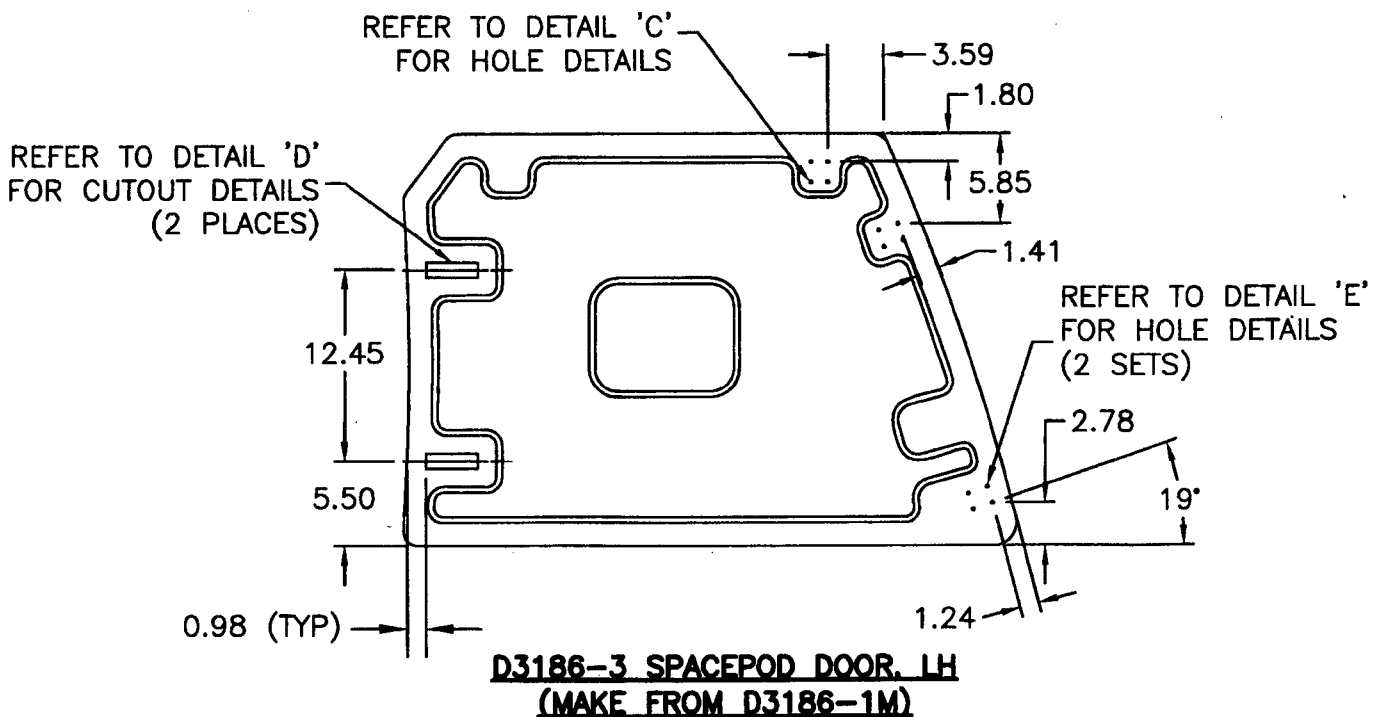
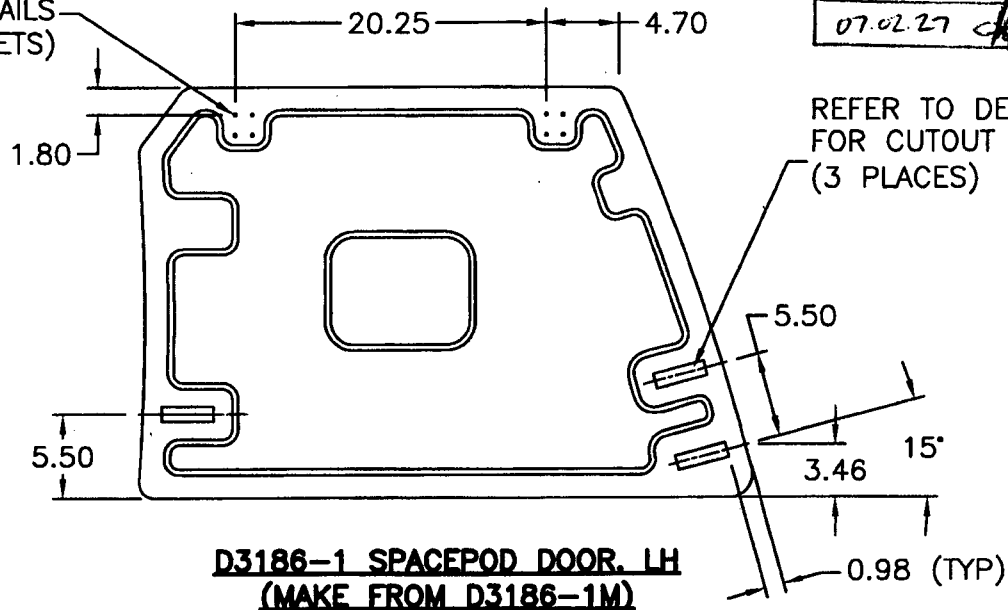
*C707105/28**W/O B 32706*

**DART**

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07.02.27

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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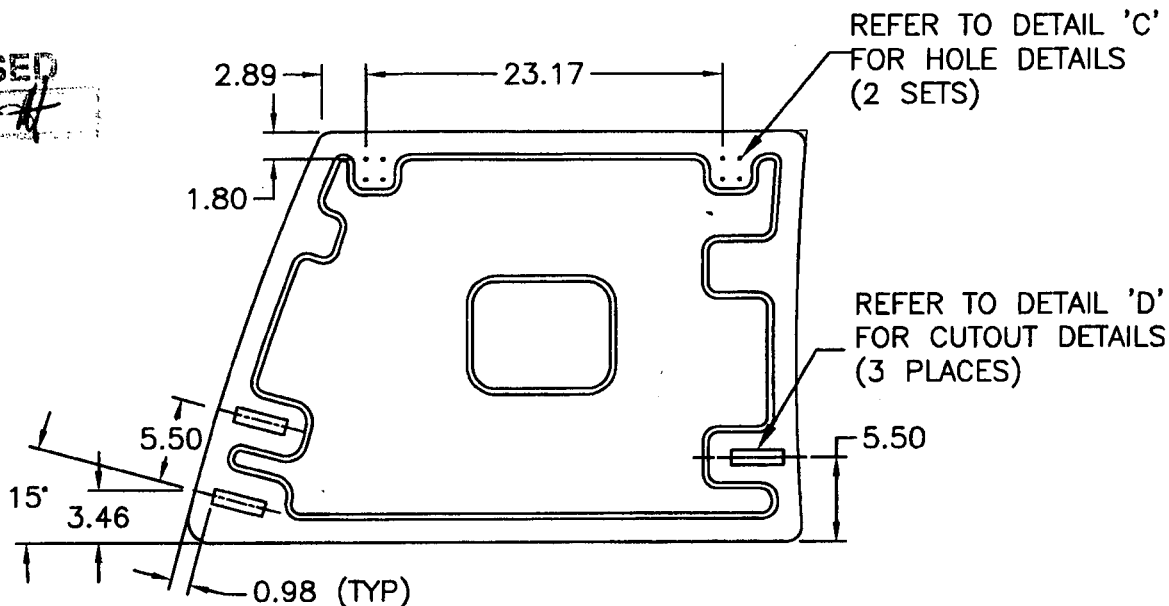
C267105128  
W/O 32706

**DART**

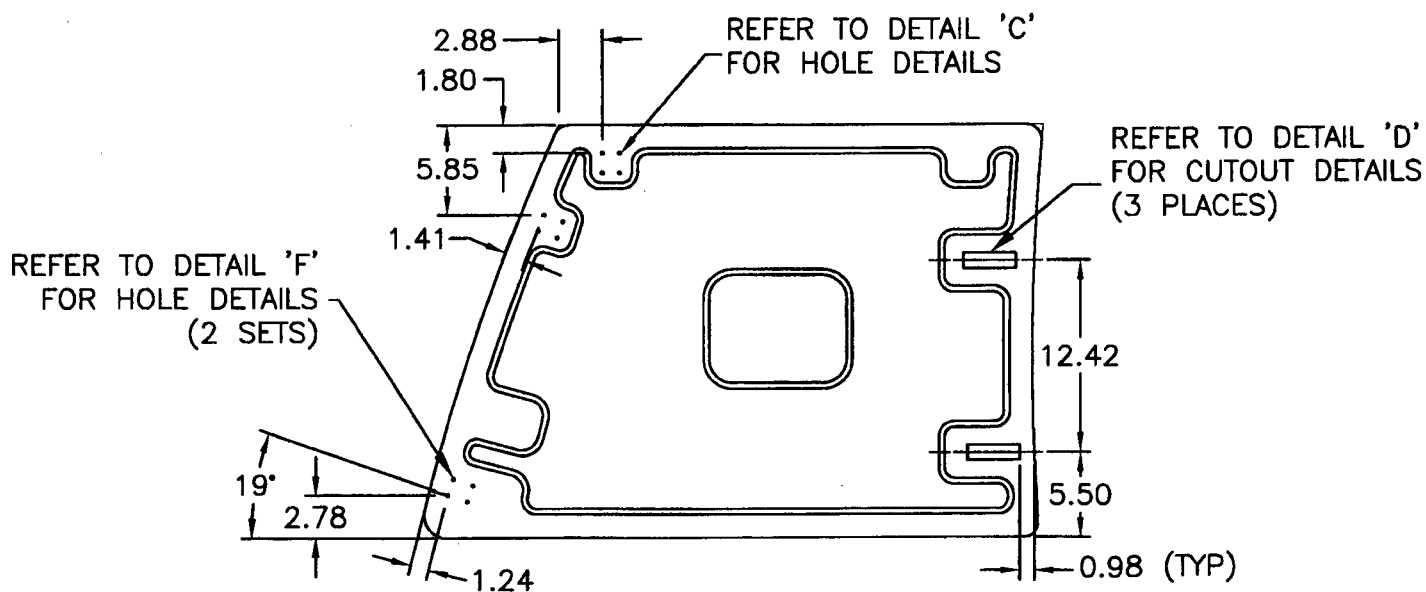
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR, RH**  
**(MAKE FROM D3186-2M)**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

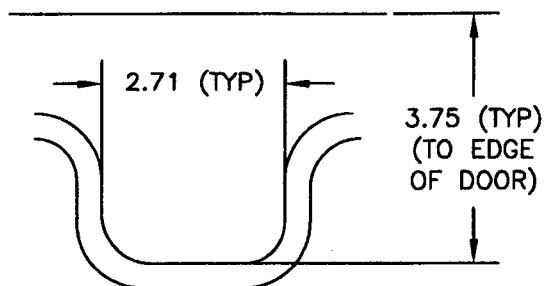
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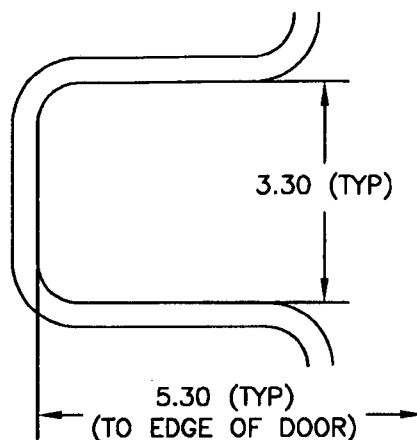
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DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS



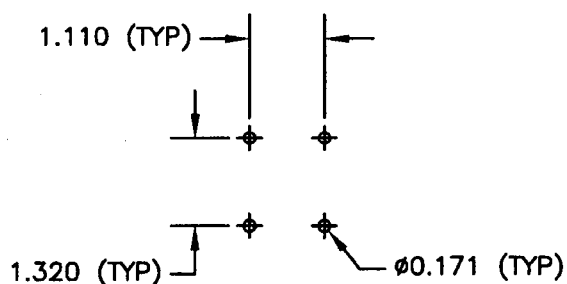
**DETAIL A**



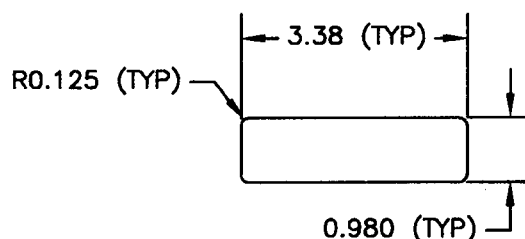
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RELEASED

07.02.22 [Signature]

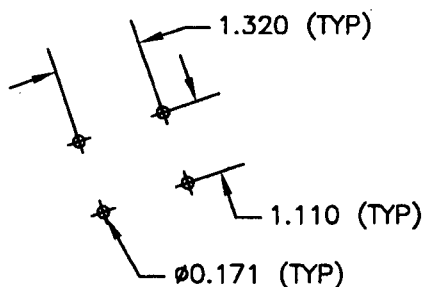


**DETAIL C**

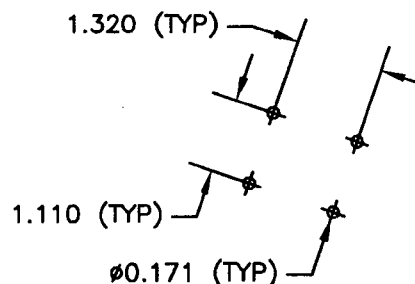


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**



**DETAIL E**



**DETAIL F**

**NOTES:**

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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C207105128  
W10 32706

Date: Jeudi, 2007-03-29 10:34:20  
 Utilisateur: Marc Dubé

## Feuille de Procédé

Client : DART Dart Aerospace Ltd.  
 Numéro Job : 41331  
 Numéro Soumission : 2586  
 Numéro B.A. :  
 Cette fois : 2007-03-29 No. B.V. :  
 Prsht Rev. : NC  
 Prem. fois : - - Type :  
 Job précédente : 41330

Nom Dessin : SPACEPOD DOOR  
 Numéro Article : DKC134-0054  
 Numéro Dessin : D3186  
 Projet Numéro : DKC134  
 Révision dessin : C  
 Matériel : Fibre 7781 et Résine 411-350  
 Date Dûe : 2007-04-05 Qté: 1 Udm: UNITE

Écrit par : \_\_\_\_\_  
 Vérifié & Approuvé par : \_\_\_\_\_  
 Commentaires : N° de pièce Dart Aerospace : D31862M




Process Sheet Rev.: 01 Modification générale selon les informations de l'ingénierie.

### Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC
Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s) Frekote 44NC		
2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs PRÉPARATION DU MOULE  Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.  Date: JUN 11 2007 Heure Début: 8:00 Heure Fin: 10:00 Sceau: 		
3.0	AC0409	Tissu à délaminer Release ply B
Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s) Tissu à délaminer Release ply B		
4.0	AC0407	Wrightlon 5200 Bleu P3
Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s) Wrightlon 5200 Bleu P3		
5.0	AC0408	Feutre de drainage N° Airweave N 10
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Feutre de drainage N° Airweave N 10		
6.0	AC0752	Stretchlon 200 poche à vide Vert
Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) Stretchlon 200 poche à vide Vert		



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41331

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish

# LOT: 1-6170-2

8.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-5964-1

9.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

10.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe:

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 22/05/07 Heure Début: 8:00 Heure Fin: 10:00 Sceau:



11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-6183-1

13.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 11 2007 Heure Début: 12:30 Heure Fin: 12:35 Sceau:



## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41331

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

14.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8004 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: JUN 11 2007 Heure Début: 12:35 Heure Fin: 12:55 Sceau:



15.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 11 2007 Heure Début: 12:55 Heure Fin: 1:05 Sceau:



Curing Début: 12:35 Curing Fin:

16.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)  
Catalyst N° DDM-9

N° de Lot: 1-5921-3

17.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6183-1

Date: Jeudi, 2007-03-29 10:34:20  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41331

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: JUN 11 2007 Heure Début: 9:00 Heure Fin: 9:15 Sceau: 

19.0	AAC0452	Polybond B46F
------	---------	---------------

Commentaire Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)  
Polybond B46F N° de Lot: 1-6066-1

20.0	DKC134-0057	Foam Core N° D3186-102 ( Porte D3186-2 )
------	-------------	--

Commentaire Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Foam Core N° D3186-102 ( Porte D3186-2 ) 1-5826-1

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
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

Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
ASSEMBLAGE GÉNÉRALE DES PIÈCES

Retirez le bagging.

Pour aider au positionnement du 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz.. Retirer le gabarit de trimage .

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer son contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Appliquer une couche de Polybond B46F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: JUN 12 2007 Heure Début: 12:30 Heure Fin: 12:50 Sceau:  

22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage



Date: Jeudi, 2007-03-29 10:34:20

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41331

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation ( entre 1 heure et 1heure 1/2 ) afin d'enlever le surplus de polybond

Date: JUN 12 2007

Heure Début: 12:50

Heure Fin: 1:05

Sceau:



Curing Début: 12:30 Curing Fin: 1:50

23.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)  
Catalyst N° DDM-9

N° de Lot:

1-5921-3

24.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6183-1

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 13 2007

Heure Début: 3:15

Heure Fin: 3:20

Sceau:



26.0

LAMINAGE.

LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: JUN 13 2007

Heure Début: 3:20

Heure Fin: 4:00

Sceau:



atq: Jeudi, 2007-03-29 10:34:20  
utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41331

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE





Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
EFFECTUER LA POCHÉ A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 13 2007 Heure Début: 4:00 Heure Fin: 4:10 Sceau:  

Curing Début: 3:20 Curing Fin: 8:00

28.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le le moule afin d'éliminer le fini lisse de celui-ci.

Date: JUN 14 2007 Heure Début: 8:05 Heure Fin: 8:10 Sceau: 

29.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  
TRIMAGE DE FINITION

Trimer les contour de la pièce l'aide du gabarit de trimage prévu à cet effet.

Date: JUN 14 2007 Heure Début: 8:10 Heure Fin: 8:30 Sceau: 

30.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S

N° de Lot: 1-6005-2

Date: Jeudi, 2007-03-29 10:34:20

Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41331

Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total: 0.2800 PINTE(s)  
Dupont Activator N° 7975S

N° de Lot: 1-6065-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total: 0.0350 GALLON(s)  
Dupont Reducer N° 12375S

N° de Lot: 1-5092-2

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

JUN 18 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

34.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run: 0.0000Hrs  
PRÉPARATION DU MATÉRIEL DART

Nettoyage 15-06-07  
Relancer 18-06-07



Appliquer une première couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.  
# Application primer

Laisser sécher pendant 3 heures.

JUN 18 2007

Date: Heure Début: Heure Fin: Sceau:



35.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs  
FINITION PIÈCE DART

JUN 21 2007



Faire le sablage de la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfection et enlever le lustre du primer.

Date: Jeudi, 2007-03-29 10:34:20  
Utilisateur: Marc Dubé

## Feuille de Procédé

Client: DART Dart Aerospace Ltd.  
Numéro Job: 41331

Nom Dessin: SPACEPOD DOOR  
Numéro Article: DKC134-0054

Numéro Job:



# Séq.: Machine ou Opération: Description :

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentaire Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)  
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6079-1

37.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentaire Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)  
Durcisseur Polysoft #004009 Sikkens

38.0 FINITION 3 FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs  
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de Sikkens.

Date: JUN 21 2007 Heure Début: 10:30 Heure Fin: 1:05 Sceau:



39.0 AAC0671 Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)  
Dupont Primer N° 1104S N° de Lot: 1-6065-2

40.0 AAC0670 Dupont Activator N° 7975S

Commentaire Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)  
Dupont Activator N° 7975S N° de Lot: 1-6065-1

41.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)  
Dupont Reducer N° 12375S N° de Lot: 1-6149-2

42.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



JUN 26 2007



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  
PRÉPARATION DU MATÉRIEL

MASSAGE + Nettoyage 22-06-07

JUN 22 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instructions du fabricant. MASSAGE + Nettoyage 26-06-07



43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

APPLICATION DE PRIMER

JUN 26 2007



Appliquer une deuxième couche de primer Dupont N° 1104S ( 7975S Activator, 12375S Reducer ) Selon I.G.

# Application de primer.

JUN 22 2007

Date: Heure Début: Heure Fin: Sceau:






**Feuille de Procédé**

Client: DART Dart Aerospace Ltd.	Nom Dessin: SPACEPOD DOOR
Numéro Job: 41331	Numéro Article: DKC134-0054

Numéro Job:	
-------------	---

# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

44.0	INSPECTION 3	INSPECTION PIÈCE DART
		

Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs INSPECTION PIÈCE DART	QTY: 1 27-06-07	 N.S.
---	-----------------	--

Emballage QT 1 27/4/07





DELASTEK COMPOSITES INC.  
2699, 5ième Avenue  
Local 14, PORTE -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\*Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12037
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

**Bill to:**

Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

**Ship to:**

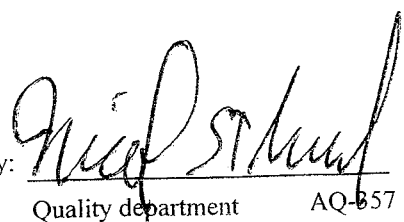
Dart Aerospace Ltd.  
1270, Aberdeen Street  
Hawkesbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/06/2007	28/05/2007	5353	C. Lavoie		PO00003852		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0052	D31861M Spacepod Door LH B21555A Dwg. Rév.: D Job: 41321 U de M : Each			
1	0	1	DKC134-0054	D31862M Spacepod Door RH B32706 Dwg. Rév.: D Job: 41331 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:   
Quality department AQ-657



☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.